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(54) ELECTRODE MATERIAL FOR ELECTRIC DISCHARGE MACHINING AND ITS PRODUCTION

(57)Abstract:

PURPOSE: To manufacture an electrode material for electric discharge machining excellent in workability and having superior consumption characteristics, by mixing powdered W and powdered Ca, by subjecting the resulting powder mixture to compacting and sintering, and by infiltrating Cu or Ag into the obtained sintered compact so as to form a specific composition.

CONSTITUTION: The powdered W and the powdered Ca are mixed in a prescribed ratio, and the powder mixture is compacted and sintered with proper addition of a binder. It is preferable that the average grain size of above-mentioned powdered W is $2W10\mu m$ and that sintering is carried out at about $1,000W1,200^{\circ}C$ in a nonoxidizing atmosphere. Then Cu and/or Ag is infiltrated into a skeleton consisting of W and Ca obtained by the above-mentioned sintering at about $1,100W1,300^{\circ}C$, so that electrode material for electric discharge machining having a composition consisting of 0.3W3.0wt% Ca, 20W40wt% of Cu and/or Ag, and the balance W can be obtained. The above electrode material is reduced in bores, excellent in workability such as grindability, polishability, etc., and further reduced in electrode consumption in the working of super hard materials, so that long-lived electrodes can be obtained.

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